

Date: Wednesday, 22/10/2008 4:07:32 PM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : SEAT SUPPORT ASSEMBLY, LH
Job Number : 42863	
Estimate Number : 13328	
P.O. Number :	Part Number : D3784043
This Issue : 22/10/2008 S.O. No. :	Drawing Number : D3784 REV B
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 42862	Material :
Written By :	Due Date : 07/11/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JD 08.10.22</u>	
Comment : Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3763043	End Fitting Assembly, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 End Fitting Assembly, LH
 batch: B42753

FF 09/02/09

(2)

3.0	D37701	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Tube
 batch: B40978

FF 09/02/09

(2)

4.0	D37703	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Tube
 batch: B40979x1 / 42963x1

FF 09/02/09

PTO

(2)

5.0	D3763041	End Fitting Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 End Fitting Assembly
 batch: B42952

FF 09/02/09

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 4:07:33 PM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: SEAT SUPPORT ASSEMBLY, LH

Job Number: 42863

Part Number: D3784043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN960JD10L	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: 11109632

(or NAS1149Do332J) batch: _____

FF 09/02/09

(2)

7.0	MS21042L3	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: 11110399

FF 09/02/09

(2)

8.0	AN52510R20	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: 11108559

FF 09/02/09

(2)

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3784

****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented up****

****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented AFT****

FF 09/02/09

(2)

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09/02/09 42LH

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: 246

9/2/09

310

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/11

Job Completion

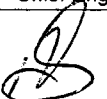

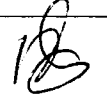



WF 09-02-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3784-043 PAR #: N/A Fault Category: Prod / Pre Assembly NCR: (Yes) No DQA: D Date: 09/02/11
D412-769-043/044 QA: N/C Closed: D Date: 09/02/11

NCR: <u>42863</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/9	# 9.0	During assembly it was found that Qty (1) D37703 has a hole that doesn't line		SCRAP and destroy D37703 B40979 Qty (1)	FF 09/02/09	S 09/02/09		S 09/02/09
		up. 2.C part was drilled off and missed on inspection on w/o # 40979		* parts in stores are line * * up. *	S 09/02/09			S 09/02/09

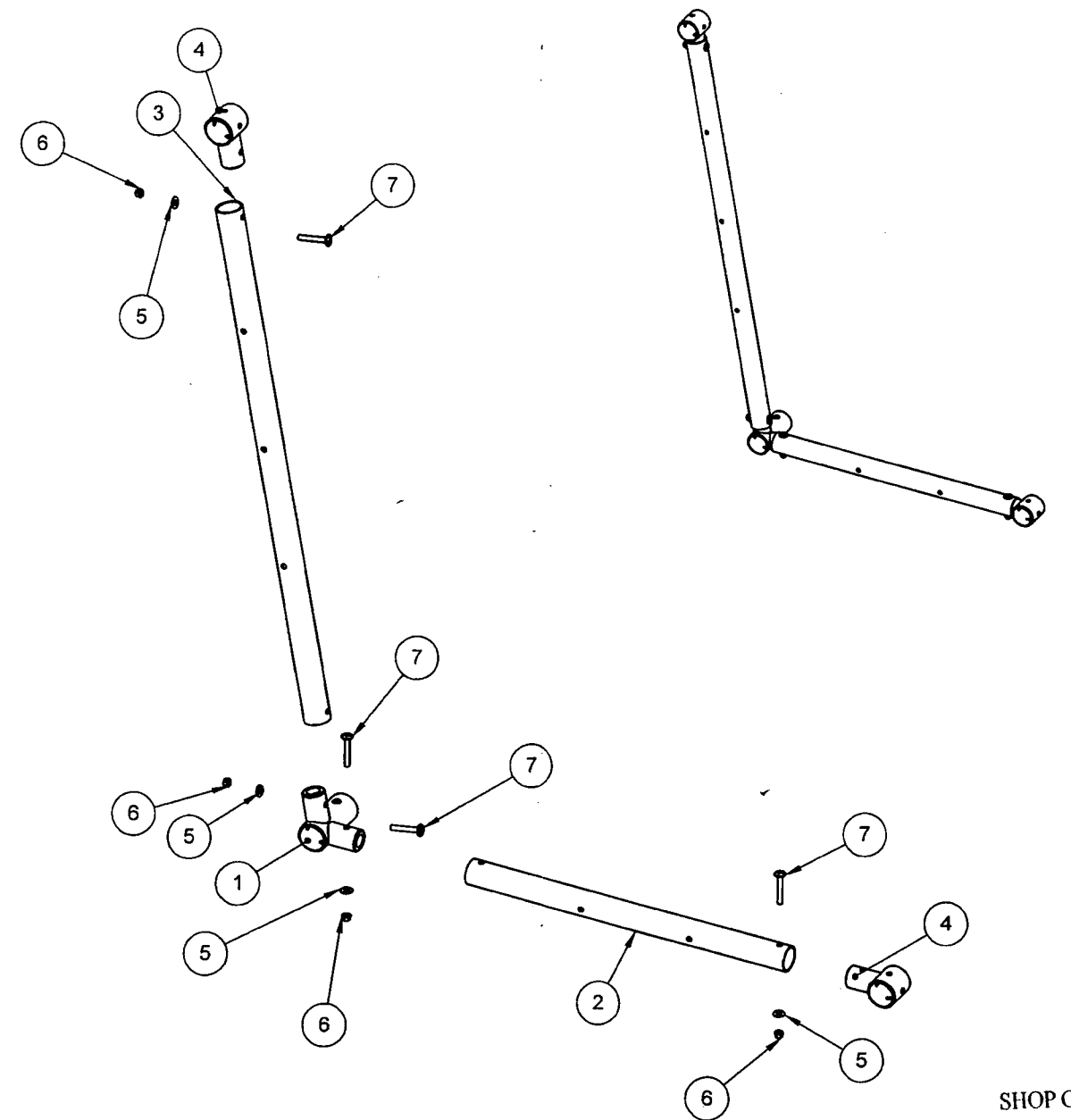
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

B
B
B



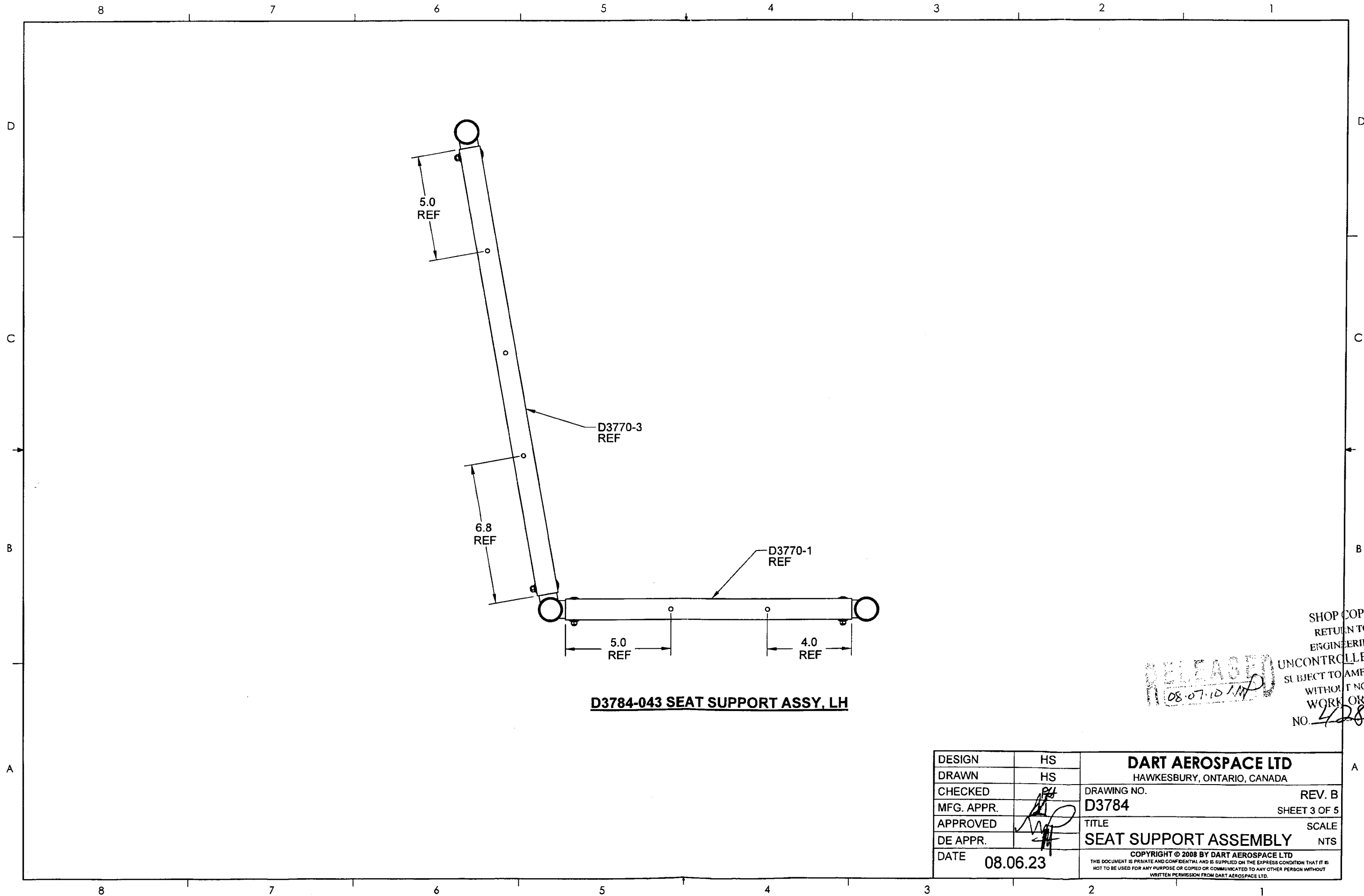
D3784-043 SEAT SUPPORT ASSY, LH

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.78 lbs

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WITHOUT NOTICE
WORK ORDER
NO 42863

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	PA	DRAWING NO. D3784
MFG. APPR.	NO	REV. B SHEET 2 OF 5
APPROVED	NO	TITLE SEAT SUPPORT ASSEMBLY
DE APPR.	NO	SCALE NTS
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8 7 6 5 4 3 2 1



RELEASED
08-07-10

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DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
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